

Work Order ID 108003

October-07-13 9:06:14 AM

Item ID: D3025-1

Accept

108003

Page 1

Revision ID:

Item Name: Beam

Start Date: 10/07/13 Start Qty: 4.00

4

Required Date: 10/07/13 Req'd Qty: 4.00

4

N900040100

Setup

Start

NS1

Stop

NS2

Reference:

Approvals:

Process Plan: MUS

Date: 13-10-08

Tooling:

Cust Item ID:

Customer:

QC:

Date:

SPC (Y/N):

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100	FLOW WATER JET								
Waterjet									
FLOW CNC Waterjet									
2024 .080"									
100		0.00							
100									
Waterjet									
FLOW CNC Waterjet									
2024 .080"									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC									
Quality Control									
120	QC8- Inspect parts - second check	0.00	DAS 27 9-89						
120									
QC									
Quality Control									
			BJ 12/9						

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear					General						
					Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>		
Centre Not Concentric to O/S					BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
Cracks <input type="checkbox"/>					Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>			
Crushed/Crimped. <input type="checkbox"/>					Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
Cuffs <input type="checkbox"/>					Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>				
Heat Treat <input type="checkbox"/>					Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
Inspection Strip in Tube <input type="checkbox"/>					Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>			
Ripples in Bend <input type="checkbox"/>					Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>					
Torque Waves in Extrusion <input type="checkbox"/>					Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
Turning Sequence <input type="checkbox"/>					Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					
Wave/Twist in Tube <input type="checkbox"/>					Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>					

Work Order ID 108003

October-07-13 9:06:14 AM

108003

Page 2

Item ID: D3025-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Beam

Stop

NS2

Start Date: 10/07/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

130

Bend as per dwg
NC BRAKE

0.00

DAS
30
9-89***130***

Brake NC

Brake NC

13/12/11

131

QC5- Inspect part completeness to step on W/O

0.00

SPH
B1Q11

4

131

QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

Memo

0.00

4

13/12/11

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS														
Part No. _____	Work Order Update	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance			Initial Chief Eng	Action Description			Sign & Date	Verification	QC Inspector						
Doc/Data																			
Equip/Tooling																			
Operator																			
Material																			
Setup																			
Other																			
Process																			
Supplier																			
Training																			
Unapproved																			
FAULT CATEGORY																			
Landing Gear				General															
Bending	Bend	Grain	Ovalized	Pressure/Forced															
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure															
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld															
Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled															
Cuffs	Contamination	Maintenance	Part Moved																
Heat Treat	Countersink	Mislabeled	Positioned Wrong																
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge																
Ripples in Bend	Drill Holes	Offset																	
Torque Waves in Extrusion	Drawing	Out of Calibration																	
Turning Sequence	Finish	Out of Sequence																	
Wave/Twist in Tube	Folio	Outside Dimensions																	

Work Order ID 108003***108003***

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October-07-13 9:06:14 AM

Item ID: D3025-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Beam

Stop

NS2

Start Date: 10/07/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

QC

Quality Control

QC1- Inspect Part Finish

0.00

DAS

27

9-89

4

160

160

Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

ST171

0.00

DAS

28

9-89

4x

13-12-11

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

J/RM 13/12/18

MP 15/12/18

NCR: Yes / No

DQA: Date: .

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/>							

Picklist Print

October-07-13 9:06:13 AM

Page 1 /1

Work Order ID: 108003**Parent Item:** D3025-1**Parent Item Name:** Beam**Start Date:** 10/07/13**Required Date:** 10/07/13**Start Qty:** 4.00**Required Qty:** 4.00**Comments:** IPP C01.10.26Added Bending as per Drawing. SM IPP REV:D 11.05.16 MAT'L
THIKNESS CHG DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	103.1700	0.75	131578948 4.0		Jm13 12-9	

Location	Loc Qty	Loc Code
MAT022	103.17	
123217	27.75	
125636	25.92	
M126161	49.5	

127668

127668

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Use-as-is <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>						
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabelled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled

DART AEROSPACE LTD	Work Order:	108003
Description: Beam	Part Number:	D3025-1
Inspection Dwg: D3025	Rev: B	Page 1 of 1

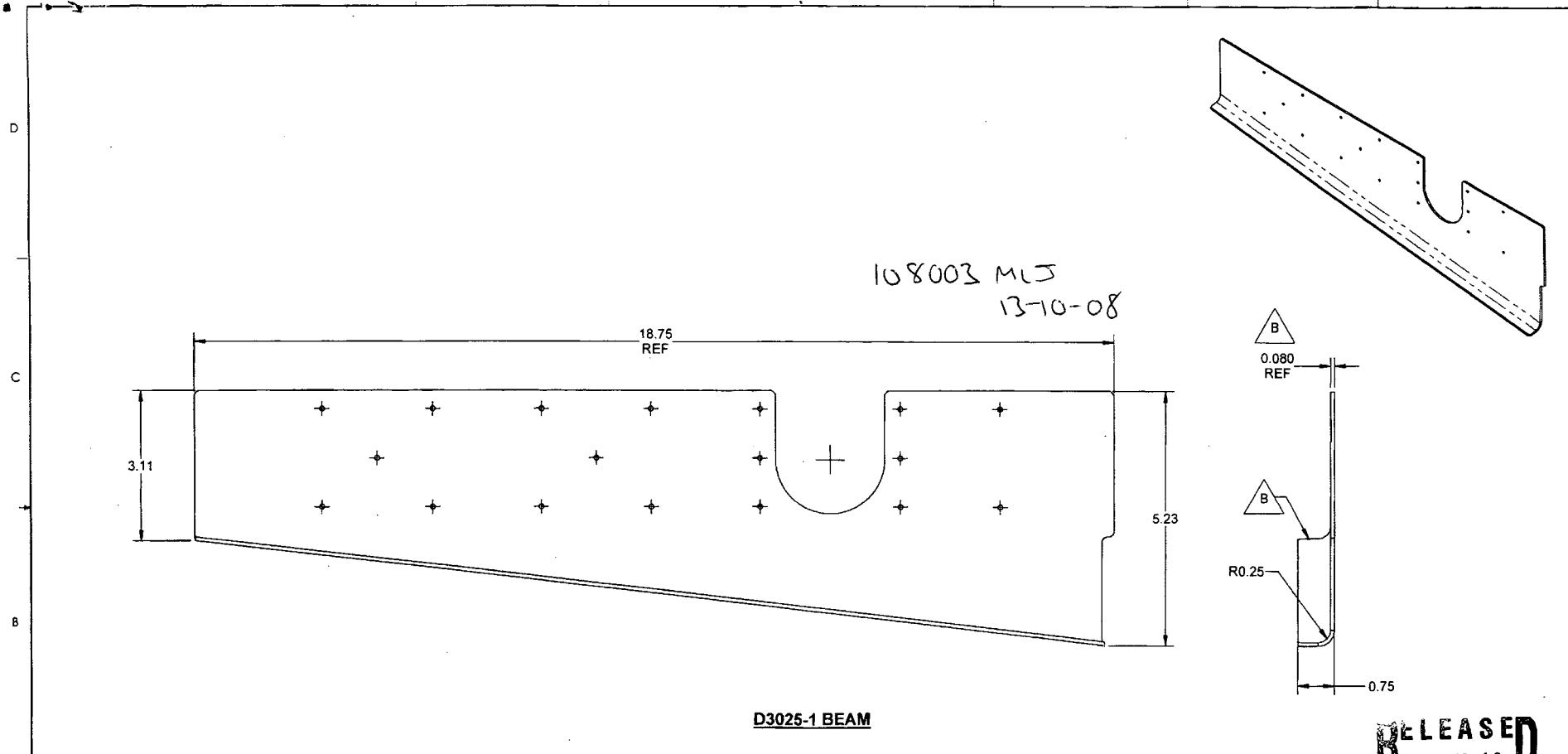
FIRST ARTICLE INSPECTION CHECKLIST

DAS

Measured by:	Jm	Audited by:	27 9-89	Preliminary Approval:	
Date:	13-12-9	Date:	13-12-9	Date:	

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D350-689-013	KJ/JLM	
B	12.07.31	Dimensions updated per Dwg Rev B	KJ	

8 7 6 5 4 3 2 1

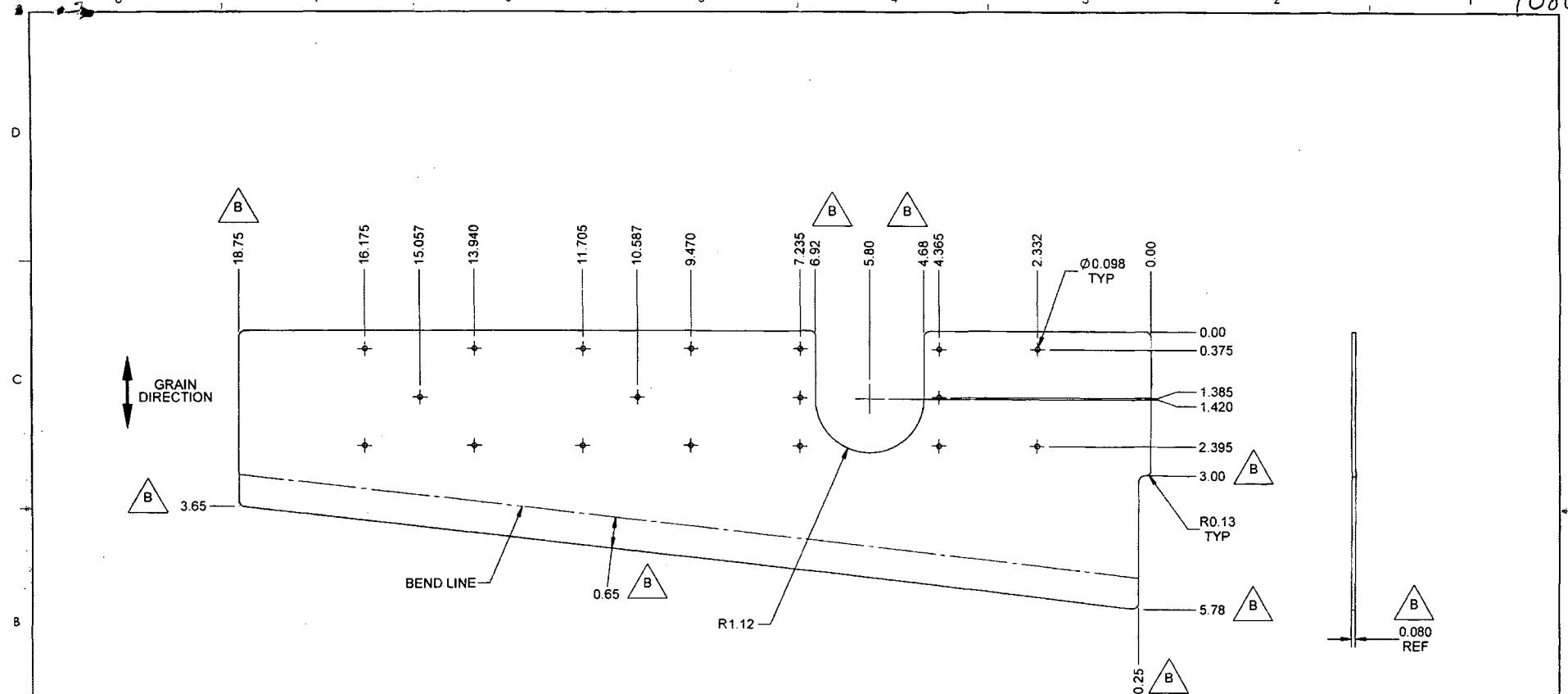


RELEASED
2011-05-18

NOTES:
 1) MATERIAL: MAKE FROM D3025-1F FLAT PATTERN
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES. 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 7) WEIGHT: 0.67 lbs

B	5.78 WAS 6.564 (ZN B2-2); 0.080 WAS 0.050 (ZN C2-1 & B1-2); DIMENSIONS CHANGED TO 2 DEC PLACES; REVERSE BEND	RF	11.05.11
A	NEW ISSUE	RF	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3025	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BEAM	NTS
DATE	11.05.11	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

108003



D3025-1F FLAT PATTERN

RELEASED
2011-05-18
MJO

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC M2024T3S.080
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

DESIGN DRAWN	RF	DART AEROSPACE LTD
CHECKED	RF	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	RF	REV. B
APPROVED	RF	SHEET 2 OF 2
DE APPR.	RF	SCALE
DATE 11.05.11	RF	NTS

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